

Work Order ID 134441

134441

Page 1

Wednesday, July 08, 2015 3:14:39 PM

Item ID: D350-589-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Side Door Latch Modification
 Start Date: 7/01/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: JUL 10 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
INN-D350-589	E		JA						SH 1508-07

100	Document Control	0.00							60-6 20 DAS
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type label as per PPP D350-589-011 CHG002								

AUG 11 2015

105	Pick Kit	0.00							DAS 27 \$ 29
105									
Packaging	Memo	0.00							
Packaging									

(4) JA AUG 06 2015

110	QC4- 100% Inspect kits for completeness	0.00							DAS 02 9-89
110									
QC	Memo	0.00							
Quality Control									

AUG 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Wednesday, July 08, 2015 3:14:39 PM

134441

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Side Door Latch Modification

Start Date: 7/01/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/07/15 **Req'd Qty:** 4.00 ***/***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per QSI 014
Location :FG022

DAS
02
9-89

AUG 11 1984

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.01

Quality Control

ML5 AUG 11 2015

mf
15-8-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Page 1

Wednesday, July 08, 2015 3:14:38 PM

Work Order ID: 134441

134441

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2237		Manufactured	No			105	Each	56.0000	3	12			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2237

Striker Plate

DAS
02
9-89

Location

Loc Qty

Loc Code

ST005

56

121746

2

128358

30

130824

24

12

D2583		Manufactured	No			105	Each	26.0000	3	12			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2583

Latch Bracket

DAS
02
9-89

Location

Loc Qty

Loc Code

ST481

26

126359

8

132718

18

4

8

D2585		Manufactured	No			105	Each	64.0000	3	12			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2585

Latch Clamp

DAS
02
9-89

Location

Loc Qty

Loc Code

ST008

22

127709

2

132766

20

ST012a

42

130053

42

9

3

**

JA

AUG 06 2015

DAS
27
\$-59

**

JA

DAS
27
\$-59

**

JA

DAS
27
\$-59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval					
Description Work Order Deviation				Disposition				Completed By				
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Root Cause		FAULT CATEGORY										
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐							
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐							
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Misidentified ☐	Past Due ☐											
		OTHER :										

Picklist Print

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Work Order ID: 134441

134441

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

D2586

Manufactured No

105

Each

40.0000

3

12

D2586

Door Latch

JA

DAS

27

8-89

DAS
02
8-89

Location

Loc Qty

Loc Code

FG

16

100607

1

114985

5

119746

4

83893

5

95760

1

ST482

24

(129404)

24

12

D2587

Manufactured No

105

Each

18.0000

1

4

D2587

Door Plug

JA

DAS

27

8-89

DAS
02
8-89

Location

Loc Qty

Loc Code

ST008

18

(121824)

6

132626

12

4

D2589

Manufactured No

105

Each

36.0000

1

4

D2589

Keys, Key Chain

JA

AUG 06 2015

DAS

27

8-89

DAS
02
8-89

Location

Loc Qty

Loc Code

ST008

36

(132942)

36

4

DQA: _____ Date: _____



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Work Order ID: 134441

134441

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-5

Purchased

No

105

Each

1,082.000

6

24

MS20470AD4-5

RIVET, UNIVERSAL HEAD

JA

DAB

27

\$-23

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

1061

m128401

1037

m128813

24

ST310

21

m128813

21

24

MS21042L3

Purchased

No

105

Each

1,445.000

3

12

MS21042L3

Nut

JA

AUG 06 2015

DAB

27

\$-23

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

436

M131317

436

ST305

616

116549

12

126333

49

M128401

2

M128754

2

M132123

17

M132382

534

m132883

12

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐								

Picklist Print

Page 4

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134441

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 7/01/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15

Purchased

No

105

Each

778.0000

3

12

MS27039-1-15

JA

DAS

Screw

27

\$39

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

59

m127916

59

ST273A

600

m132640

600

ST285

119

m127916

16

m130388

3

m132317

100

NAS1149D0363J

Purchased

No

105

Each

2,109.000

3

12

NAS1149D0363J

JA

AUG 06 2015

DAS

Washer

27

\$39

DAS
02
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

1126

m128429

138

m132677

988

ST269

414

m126319

7

m131618

1

m132317

406

Wednesday, July 08, 2015 3:14:39 PM

Shop Packet Print

Page 4

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.